

Date: Wednesday, 4/4/2007 9:01:16 AM
 User: Kim Johnston

Process Sheet

Split
SB 07/03/14

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SCUFF PLATE
Job Number	: 31604	Part Number	: D206555003
Estimate Number	: 11952	Drawing Number	: D206-555 REV C
P.O. Number	: <i>N/A</i>	Project Number	: <i>N/A</i>
This Issue	: 4/4/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: C
Prsht Rev.	: NC	Material	: <i>NA</i>
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Due Date	: 4/20/2007
Previous Run	: 29020	Qty:	<i>10</i> Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: est rev C 99.06.29 returned to electro polish DM Est Rev:D Now on Waterjet 06-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form parts on hydraulic press as per Dwg. D206-555
 using DT 8316-3

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.4148 sf(s)/Unit Total: 4.1475 sf(s)
 304/316 .020" Sheet 25GA
 Batch: *M103509*

SAD 07/06/04 10

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D206-555
 Dwg Rev: *C*
 Prog Rev: *C*

2-Deburr if necessary

→ SAD 07/06/12 (10)
SAD 07/06/04 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/11 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

7-06-12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/15	6	split w/o	SB	07/08/15	1		
07/08/14	6		SB	07/08/14	8		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:01:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8317-3

Polish with line mate SB 07/10/12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: _____

Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

N/A 07/10/11

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-10-12 Inspected 4 parts (don't know how many splits?)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev 7/10/12 scd (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
31/12/12	6	Split ut	SB	27/10/12	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:01:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

19
2007/10/12

Job Completion



U 07-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

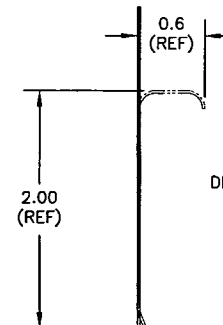
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31604*

RELEASED
06.09.19 *[Signature]*

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FLAT PATTERN



SECTION A-A
DETAIL OF BENDING
SHOWN

2.7
(REF)

8.000

Ø0.187
(2 PLACES)

14.1
(REF)

RELEASED

06.04.19

NO. 31607
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

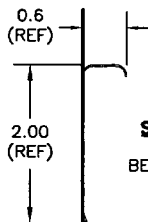
D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)

D206-555-002 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY [Signature]	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 2 OF 7 SCALE 1:1



SECTION C-C
DETAIL OF
BENDING SHOWN

DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

2.7
(REF)

16.000 (REF)

NO. 31604
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

RELEASED

06.09.19

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)

D206-555-004 (BEND OPPOSITE)

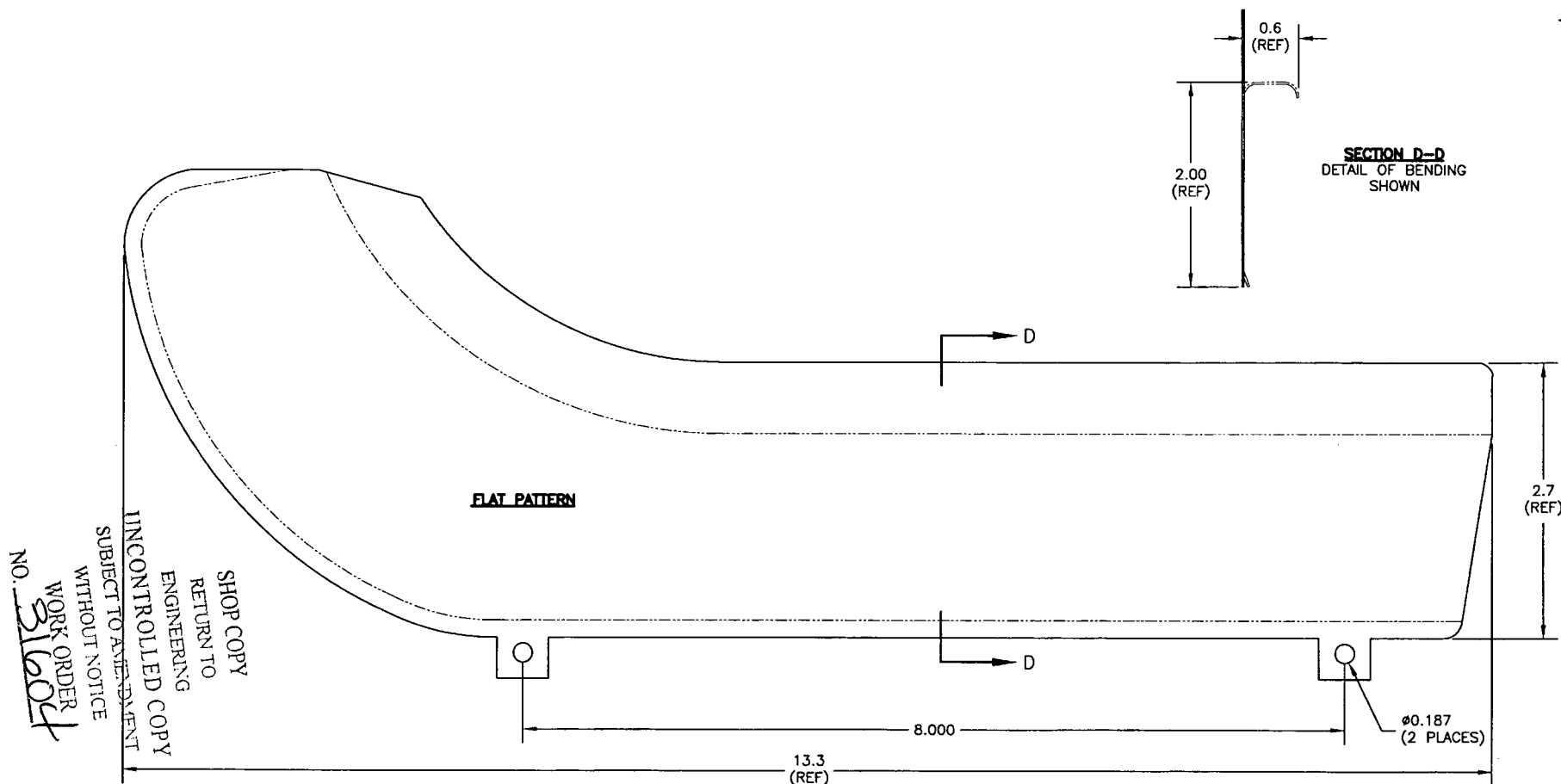
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

Hand Polish
using Line Mate
and S.F. fine drums.

DESIGN JB	DRAWN BY [Signature]	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

05.10.12



NO. 31604
WORK ORDER
SUBJECT TO AWARD
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

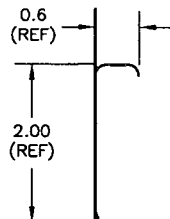
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

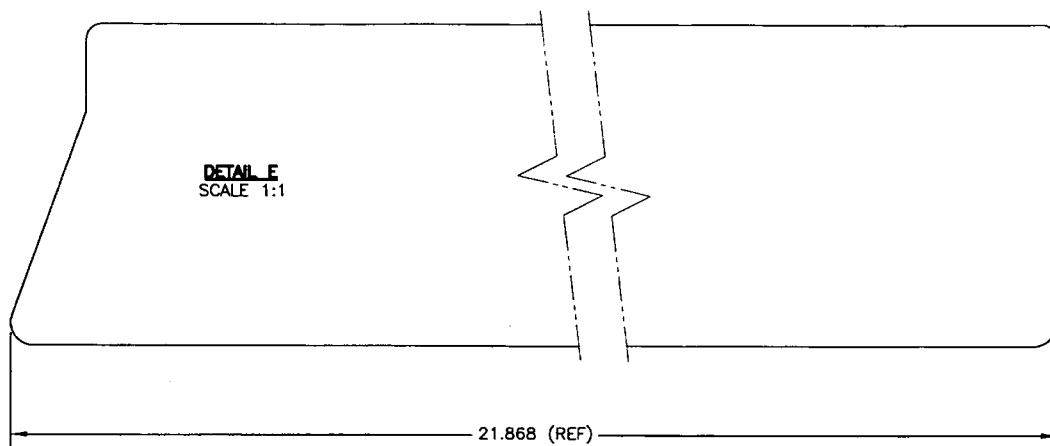
RELEASED

06-09-19

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION F-F
DETAIL OF
BENDING SHOWN

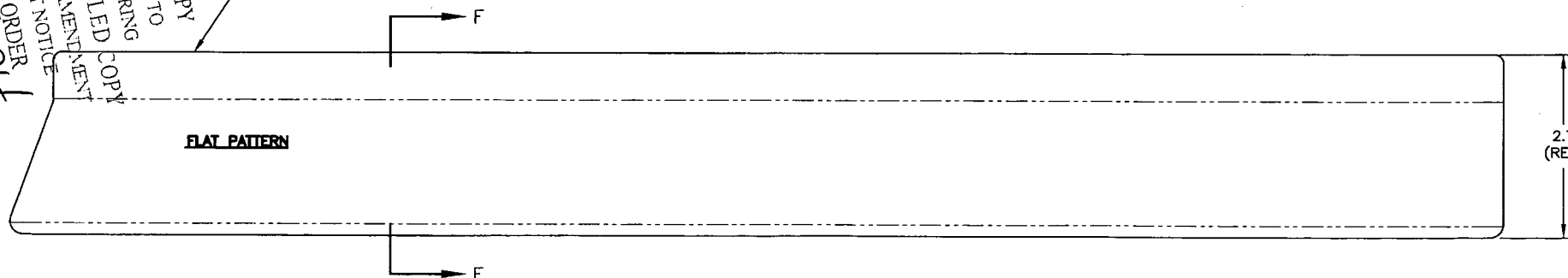


DETAIL E
SCALE 1:1

21.868 (REF)

REFER TO DETAIL E
FOR 1:1 SCALE

NO. 31604
WORK ORDER
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ENGINEERING
RETURN TO
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FLAT PATTERN

2.7
(REF)

RELEASED

06.09.19 #

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

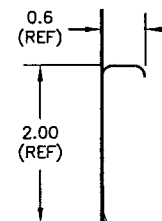
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY #	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. D206-555	REV. C SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

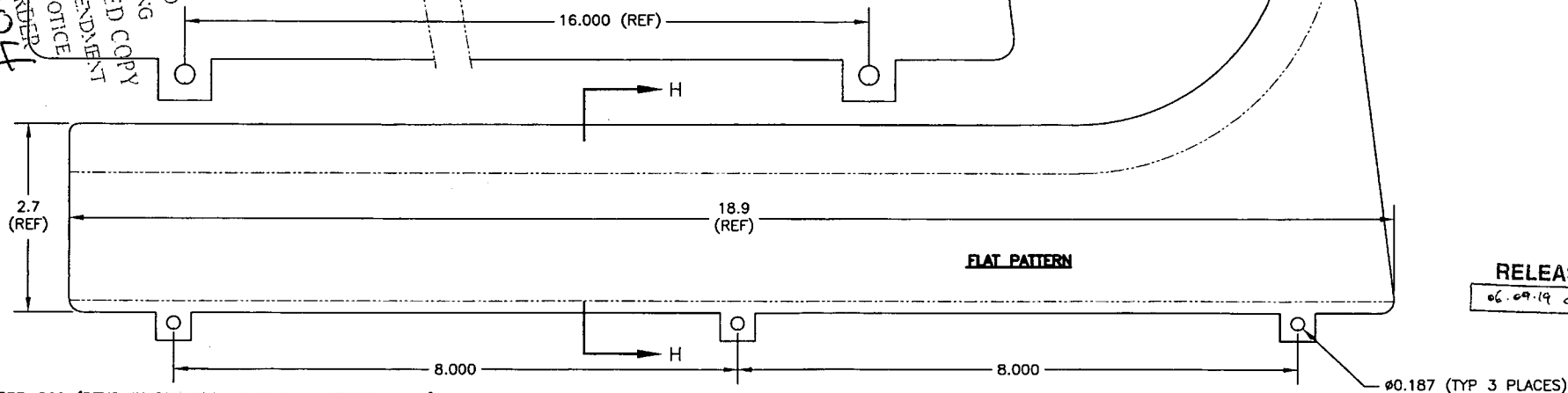
NO. 31604
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DETAIL G
SCALE 1:1



SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE



RELEASED

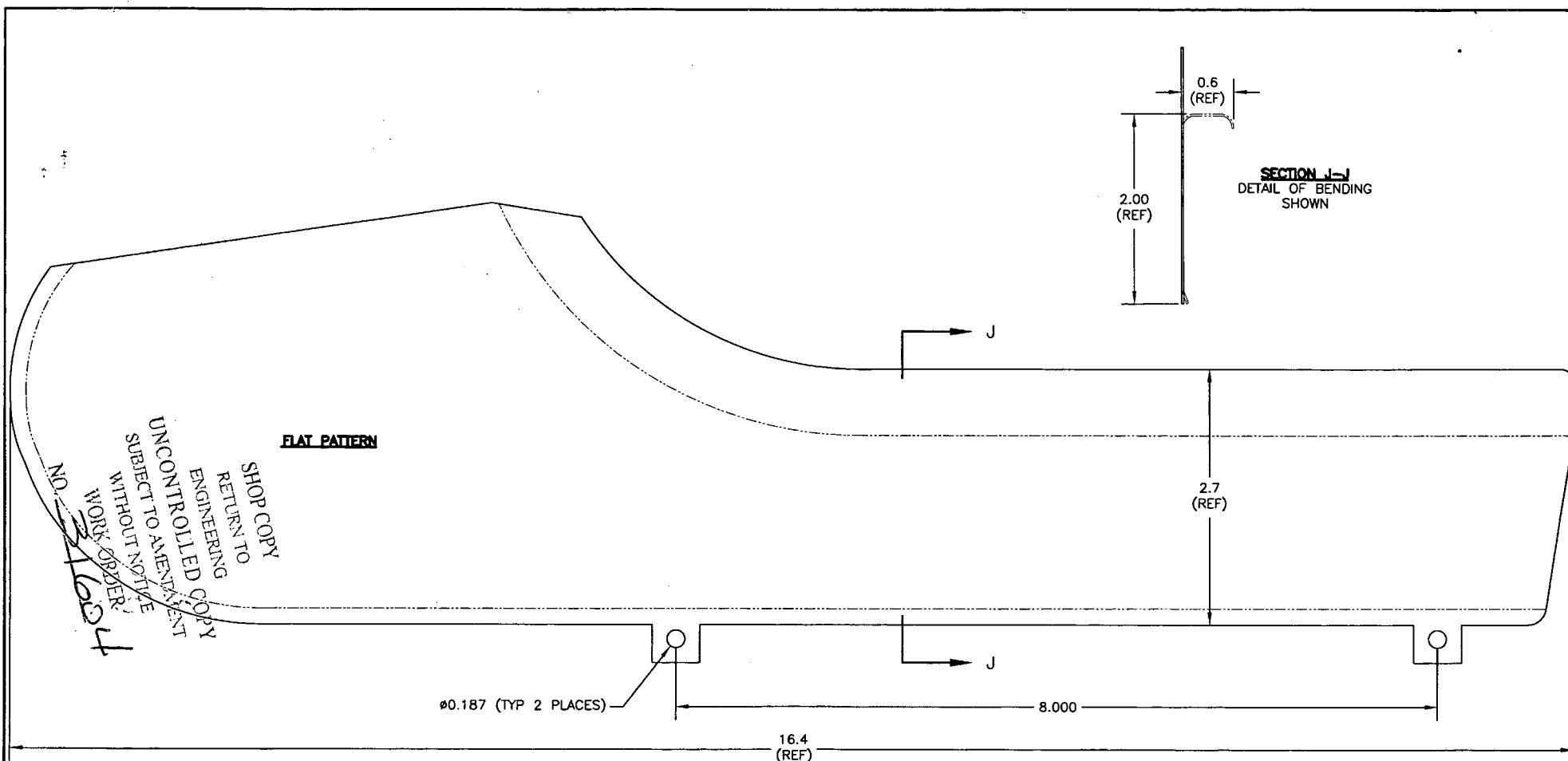
06.09.19

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.01

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

0000

DART AEROSPACE LTD		Work Order: 31604
Description: Scuff plate		Part Number: D206555003
Inspection Dwg: D206555 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.7	+/- 0.100	2.701	✓		Vern	
B 8.000	+/- 0.010	8.005	✓		Vern	
C 8.000	+/- 0.010	8.007	✓		Vern	
D 19.0	+/- 0.100	19.0	✓		Vern	
E Ø0.187	+0.001/-0.001	Ø0.190	✓		Vern	
F 0.020	+/- 0.010	0.027	✓		Vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: JAN	Audited by: [Signature]	Prototype Approval: N/A
Date: 07/06/11	Date: 07/06/11	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

CUSTOMER RETURN

Initiator: Jan Keer Date: Nov 30/07
 Company: Rotor Components (Helicopter) Invoice # 4683
CROTOLO Order Entry # 4202
 Phone No. 011 618 9414 1114
 Reason for return: Extremely BAD quality. Attach Copy of DHS Return Authorization # 371
Customer doc

Receiving: 14
 Date Received: 8/2/15 Freight Company: FedEx Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-001	26008	SCUFF Plate Fwd LH		
1	D206-555-002	25499	" " RH		
1	D206-555-003	31604	SCUFF Plate Aft LH		
1	D206-555-004	30264	" " RH		
				<u>DAVE</u>	<u>8/2/15</u>

Condition of packaging: Good Photograph required: yes ☐ no ☒
 Paperwork attached: P/S ☒ Invoice ☒ ARC ☐ Docs ☐ Other ☐

QC: Quarantine: Location: [Signature] Condition of Part: good
 Inspect: Initial: [Signature]

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-001	B26008	Return to stock as per W/O's Scrap & destroy as per W/O.	<u>[Signature]</u>	37671	<u>[Signature]</u>
1	D206-555-002	B25499			37672	
1	D206-555-003	B31604			37675	
1	D206-555-004	B30264			37676	

QA Coordinator: Advise GM as to findings: Initial: _____ Date: _____
 Comments: _____

Issue credit: yes <input type="checkbox"/> no <input type="checkbox"/>	Invoice Amount: _____ Less Replacement: _____ Restock Fee: _____ Freight: _____ Net Credit: _____ DHS <input type="checkbox"/> Customer <input type="checkbox"/>
GM Approval: _____ Date: _____	

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit